Date: User:
Customer Job Number Estimate Num P.O. Number This Issue Prsht Rev. First Issue
Previous Run

Wednesday, 6/27/2007 1:08:13 PM

Kim Johnston

Process Sheet



ner

: CU-DAR001 Dart Helicopters Services

: 33215

: 10725 te Number mber

: NLA : 6/27/2007

S.O. No. : NLA

: 32987

: MACHINED PARTS Type

: Est Rev:B

Now machined in house. **1**02.06.13

Drawing Name : BUSHING

: D2652 Part Number **Drawing Number**

· D2652 REV A : N/A

Project Number **Drawing Revision**

Material Due Date : 7/10/2007

Qty:

200 Um:

Each

Additional Product

Checked & Approved By

Written By

Comment

Job Number:

1



Seq. #:

Machine Or Operation:

Description:

NG

1.0

M303R0500

303 Round Bar 0.500"



Comment: Qty.:

0.0578 f(s)/Unit Total:

11.5500 f(s)

Material:303 ss .500" Round Bar

(M303R0500)

Batch: MIOY919

HARDINGE



2.0

Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA250 & Dwg D2652

2-Deburr

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



4.0

3.0

QC8





Comment: SECOND CHECK

PACKAGING 1 5.0

PACKAGING RESOURCE #1







Comment: PACKAGING RESOURCE #1

Identify and Stock Location:



Page 1

Form: rorocess

Dart Aerospace Ltd

W/O:		,	WORK ORDER C	HANGES				
DATE	STEP	į.	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		<u> </u>	· · · · · · · · · · · · · · · · · · ·			+		,
Part No):	P	AR #: Fault Category:	NCR: Yes	No) DQ	A: <u></u>	Date: <	Moslos

QA: N/C Closed: ____ Date: ____

NCR:		3	WORK ORD	ER NON-CONFORMAN	CE (NCR)			
		Description of NC Corrective Action Section B			Verification	A1		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
1				· · · · · · · · · · · · · · · · · · ·				

NOTE: Date & initial all entries

Date:

Wednesday, 6/27/2007 1:08:13 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 33215

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



[107.02.02.0Z

Dart :	Aeros	pace	Ltd
--------	-------	------	-----

Dail At	Tospace	Liu								
W /O:			WC	RK ORDER CHAN	IGES			•		
DATE	STEP	PR	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			· ·							
Part No	:	PAR #:	Fault Categ	ory:	NC	R: Yes	No DQ/	A :	_ Date: _	
						QA: N	/C Closed	d:	_ Date: _	
NCR:			WORK ORDE	R NON-CONFORM	IANCE	(NCR)		-	
DATE	0750	Description of NC	intion of NC Corrective Action Section		ection B		Verification			Annewal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Section		Approval Chief Eng	Approval QC Inspector
									:	
,										
									1	
			-							

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33215
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Pr	ototype
---	---------------	----	---------

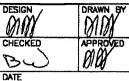
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
· 0.600	+/-0.010	,599				
0.060	+/-0.005	.060 .304				
Ø0.305	-0.002/+0.000	:304	1			
Ø0.191	+0.005/-0.000	0191	1			
Ø0.500	+/-0.010	. Hag	\ \			
0.030 x 20°	+/-0.010	.030<20	1			
R0.010	+0.010/-0.000	20.015				
		···				
	,					
4.0						
		49				

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 07 % 01	Date: 07-57.51	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.12	New Issue	KJ/RF	- 74







97:03:25

DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA

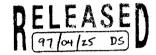
DRAWING NO. D2652

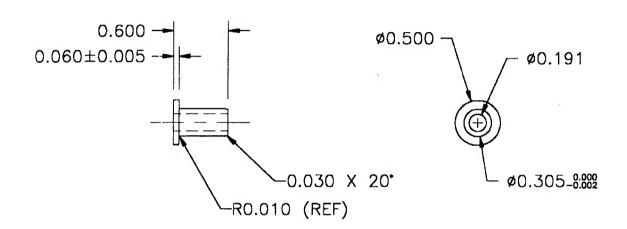
REV. A

SHEET 1 OF 1 SCALE

TITLE

BUSHING





MATERIAL: AISI 303 SS

BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QST 018 UNLESS OTHERWISE SWOPEDPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT WITHOUT NOTICE